

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QS1042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
										QC / QA Coordinator Approval															
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
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LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

Wednesday, July 08, 2015 3:11:30 PM

134366

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Pedal Lock Cover

Start Date: 7/07/15 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 7/07/15 **Req'd Qty:** 4.00 ***/***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.01

Hand Finishing

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

Work Order ID 134366

134366

Page 3

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Item ID: D3368-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Pedal Lock Cover
Start Date: 7/07/15 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 7/07/15 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
132	QC7-Inspect Chemical Conversion Coat	0.00							
132									
QC	Memo	0.00							
Quality Control									
140	Fire Red(Ref:4.3.5.10) per QSI005 4.3	0.00							
140	M129228								
Powdercoat	Memo	0.00							
Powder Coating									
	Heat oven at temperature for 45 minutes before putting part in oven by: _____								
	Start Time: 2:55								
	Oven Temperature: 320°								
	Finish Time: 3:40								
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									

6 φ 15-11-24 DAS 34 9-89

6 φ 15-11-24 DAS 34 9-89

⑥ DAS 38 9-89 NOV 25 2015

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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Work Order ID 134366

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134366

Page 4

Item ID: D3368-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Pedal Lock Cover

Start Date: 7/07/15

Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/07/15

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: St496

0.00

160

Packaging

Memo

0.03

Packaging

6NOV 25 2015INS
6
9-85

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.01

Quality Control

MCJ15-11-250151125

DQA: _____ Date: _____



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Root Cause		FAULT CATEGORY																							
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Picklist Print

Wednesday, July 08, 2015 3:11:29 PM

Page 1

Work Order ID: 134366

134366

Parent Item: D3368-3

D3368-3

Parent Item Name: Pedal Lock Cover

Start Date: 7/07/15

Required Date: 7/07/15

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP A05.01.27New issueKJ/JLM

IPP Rev:B 08-07-15 add QC3 DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6B2.000X02.00

Purchased

No

100

f

21.2500

0.8835

~~3.72~~

5.301

0

M6061T6B2 000X02 000

215-11-16

6061-T6 Bar 2.00 x 2.00

Location

Loc Qty

Loc Code

MAT004

21.25

m129375

21.25

5.58

DQA: _____ Date: _____



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OTHER : ☐																					

DART AEROSPACE LTD		Work Order: 134366
Description: Pedal Lock Cover		Part Number: D3368-3
Inspection Dwg: D3368	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

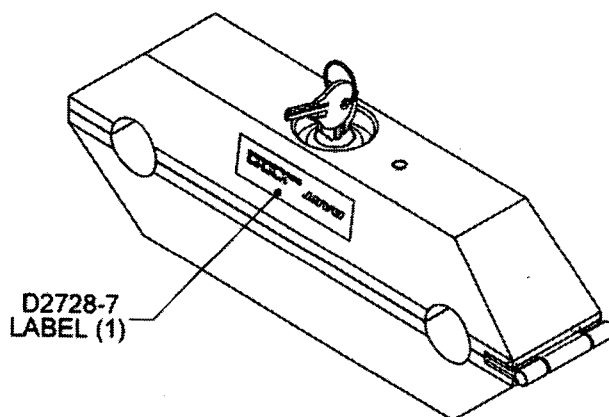
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.25	+/-0.030	10.255	✓		HG	
7.250	+/-0.010	7.250	✓		VERN	CNC-02
0.650	+/-0.010	0.649	✓		-	SL-10
0.107	+/-0.010	0.107	✓		-	
1.800	+/-0.010	1.799	✓		-	
45°	+/-0.5°	45°	✓		protractor	
Ø1.300	+/-0.010	1.299	✓		-	
Ø1.400	+/-0.010	1.400	✓		-	
Ø1.031	+/-0.010	1.030	✓		-	
0.250	+/-0.010	0.250	✓		-	
1.500	+/-0.010	1.500	✓		-	
1.440	+/-0.010	1.441	✓		-	
2.00	+/-0.030	1.999	✓		-	
7°	+/-0.5°	7°	✓		protractor	
0.635	+0.010/-0.000	0.641	✓		VERN	
Ø1.250	+/-0.005	1.249	✓			
0.250 deep	+/-0.010	0.249	✓			
1.000	+/-0.010	1.000	✓			
1.450	+/-0.010	1.450	✓			
0.375	+/-0.010	0.376	✓			
0.310	+/-0.010	0.311	✓			
Ø0.750	+0.010/-0.000	0.754	✓			
Ø0.185	+0.005/-0.000	0.185	✓			

Measured by: SL	Audited by: [Signature]	Prototype Approval:	N/A
Date: 15-11-19	Date: 15/11/24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	05.05.25	Dimensions and tolerances changed	KJ/JLM	
C	08.07.23	Ø0.201 & Ø0.136 dimensions removed	KJ/DD	

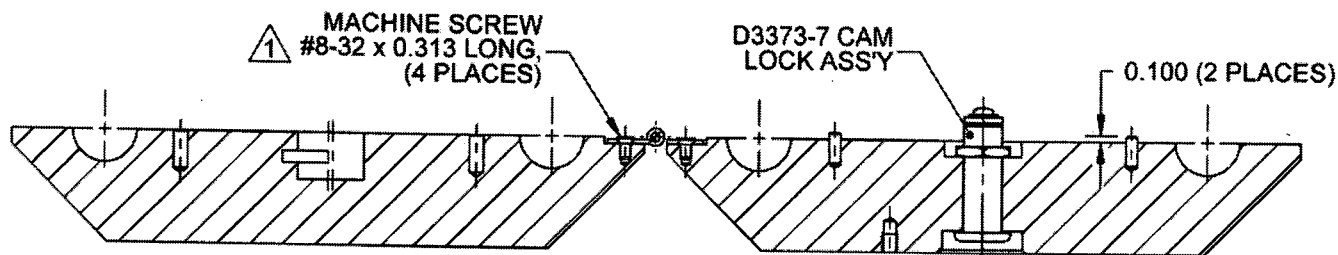


DESIGN 3	DRAWN BY 3	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RT	APPROVED [Signature]	DRAWING NO. D3368	REV. B SHEET 1 OF 3
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:3
A	05.01.19	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	

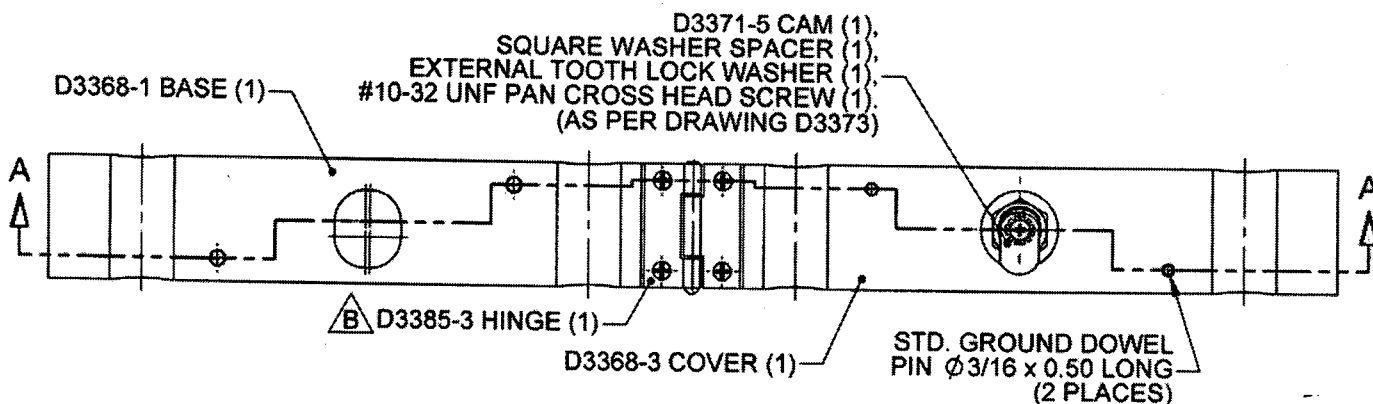


RELEASED
[Signature]
05/04/20

PEDAL LOCK SHOWN LOCKED WITH KEY



SECTION A-A



D3368-051 PEDAL LOCK ASSEMBLY

NOTES:

- 1) POSSIBLE SUPPLIER: SPAENAU P/N 385-044
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

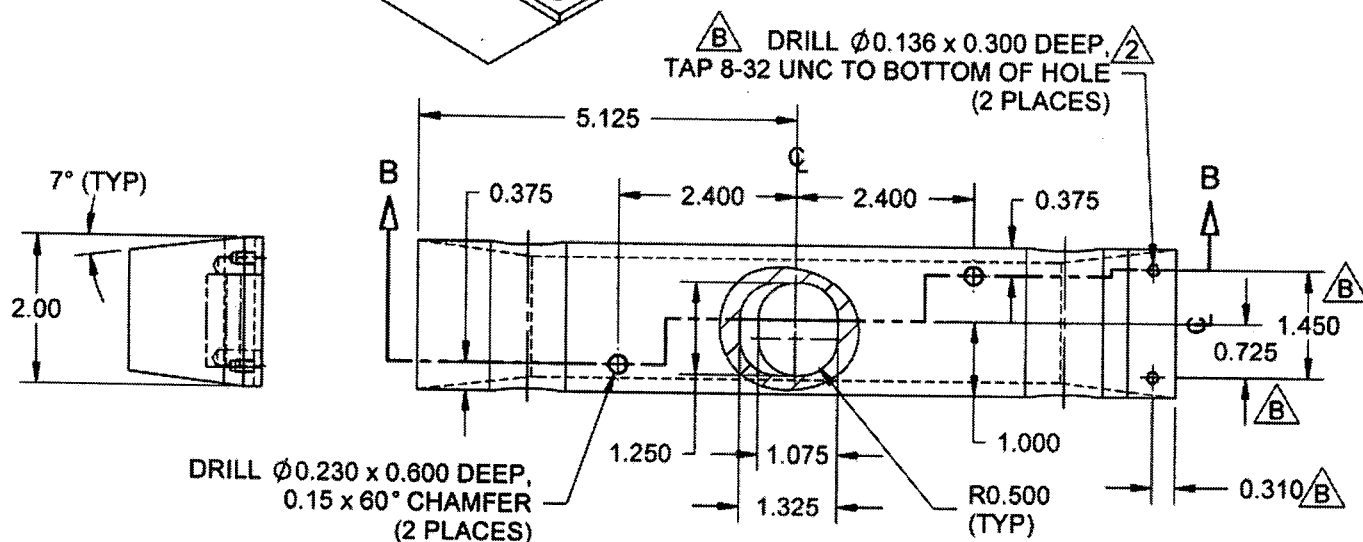
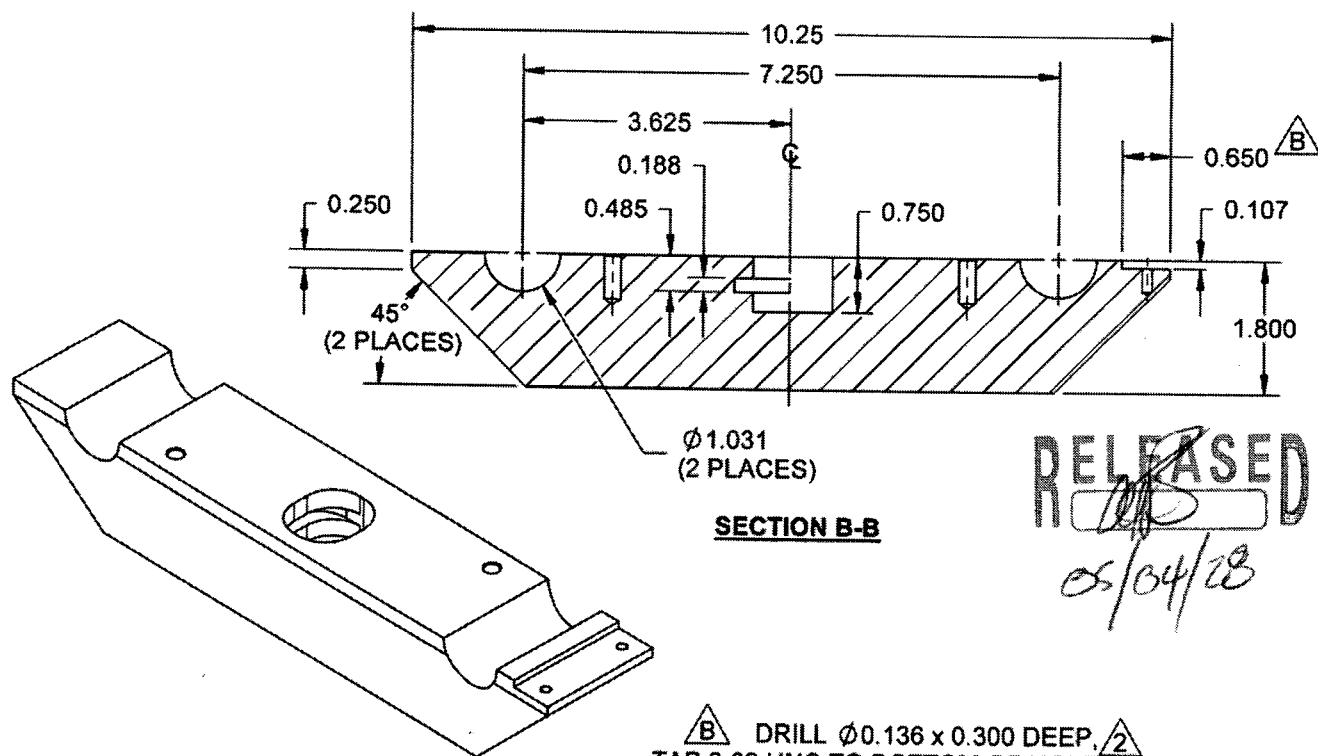
134366 M15
1507-09
[Vertical text: SUPPLY, PART NO, QTY, UNIT, COMMENTS]

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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3368	REV. B SHEET 2 OF 3
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:2.5



D3368-1 BASE

NOTES:

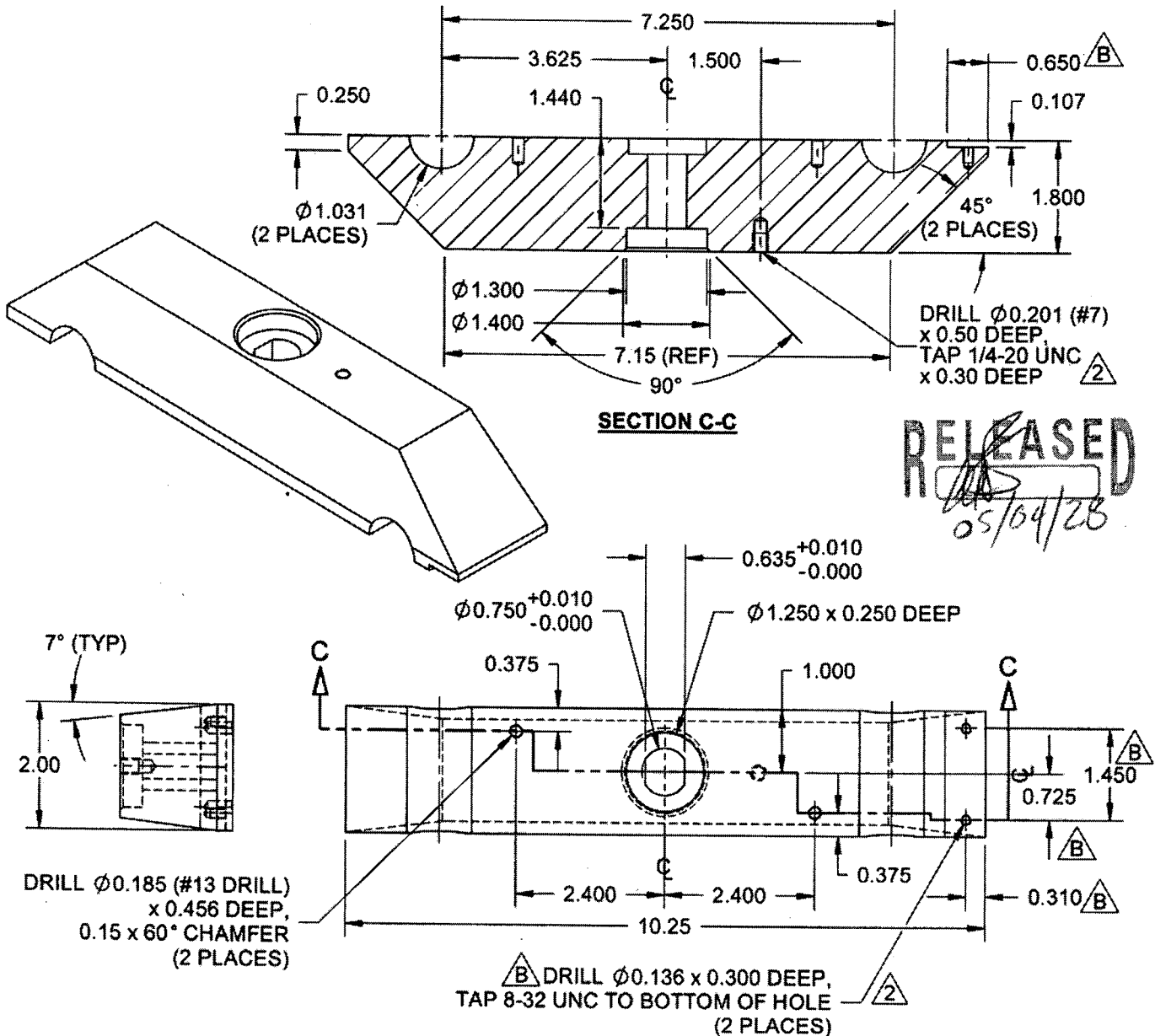
- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 05.03.22	TITLE PEDAL LOCK		SCALE 1:2.5



D3368-3 COVER

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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